

WHAT IS CLAIMED IS:

1. A coupling for a double tube comprising:

the coupling configured to connect with the double tube,
the double tube comprising:

5 an outer tube for a first fluid to flow therethrough; and
 an inner tube provided inside of the outer tube and
having an end protruding from the outer tube, the inner tube for a
second fluid to flow therethrough,

 the coupling comprising a branched portion brazed to an end
10 of the outer tube and brazed to an end of the inner tube, with the end
of the inner tube protruding outside through the branched portion,

 the branched portion formed as a curved tube having a curved
portion, and having an end joined to an end of the outer tube, with
the curved portion having a through-hole for the inner tube to pass
15 therethrough.

2. A coupling according to claim 1,

 wherein the curved portion has an outer surface having a
burr portion in contact with an outer peripheral surface of the inner
20 tube through the through-hole.

3. A coupling according to claim 1,

 wherein the branched portion has an end formed with an
expanded radial portion configured to receive and position axially
25 the outer tube.

4. A coupling according to claim 1,
wherein the branched portion has an end having a distal end
bent outwardly to form a brazing-material holding portion.

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5. A coupling according to claim 1,
wherein the curved part has an inner surface formed with a
stepped brazing-material holding portion configured to receive and
support a ring-shaped brazing material fitted coaxially to the inner
10 tube.

6. A coupling according to claim 1,
wherein the branched portion has an inner surface having a
brazing-material layer thereon.

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7. A coupling according to claim 1,
wherein the double tube has the inner tube movably inserted
radially into the outer tube,
wherein the through-hole is positioned to avoid a region
20 having a maximum extension in the curved portion.

8. A method of manufacturing a coupling for a double tube
according to claim 1, comprising:

bending a straight tube having an inner radial size larger
25 than an outer radial size of an inner tube, to form a curved tube

having a curved portion; and

inserting a punch member into an end of the curved tube for punching through the curved portion to form a through-hole for the inner tube to pass therethrough.

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9. A method according to claim 8,

wherein the punch member forms a burr portion on an outer surface of the curved portion, the burr portion being in contact with an outer peripheral surface of the inner tube.

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10. A method according to claim 8,

wherein the punch member forms an expanded radial portion at the end of the curved tube for receiving and positioning radially the outer tube.

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11. A method according to claim 8,

wherein the punch member bends outwardly a distal end of the end of the curved tube to form a brazing-material holding portion.

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12. A method according to claim 8,

wherein the punch member forms a stepped brazing-material supporting portion on an inner surface of the curved portion for receiving and supporting a ring-shaped brazing material fitted
25 coaxially to the inner tube.

13. A method according to claim 8, further comprising:

providing a brazing material on an inner surface of a
branched portion;

5 inserting the inner tube and the outer tube in the branched
portion; and

heating the brazing material to braze and fix the inner tube
and the outer tube to the branched portion.

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